Work Order II February-24-14 10:03	2.56 434	1	*119	*113798*							
Item ID: D340 Revision ID: Item Name: GHW		B113798	Accept	*N900	040	100*	Se	etup Start	171	S1* S2*	=
Start Date: 2/24/ Required Date: 2/24/ Reference:			l .	Cust Item II Customer:	D:						
Approvals: Pro	cess Plan: MC5	Date: 14 ()2-2	G Tooling: SPC (Y/N):	Da	·		Ru	ın Starı Stop	^i V	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Ac Code Qt	ccept	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3404	Rev C										_
100 *1	BAND SAW	30	0.00			DAS 02 9-89	R	T 14	-03	-(7	•
Jeaspa Bandsaw		blank: 2.700" long							e e		١
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110; HAAS 1 HAAS CNC vertical machi	Men ne #1 1- <u>M</u> :	achine as per Folio FA555 and D	0.00 wg D3404Dwg Rev: (Folio Rev:			10	<u> </u>		JFC 20	14-03-
· •	<u>. A</u>	A 2-Deburr		,							
*120	QC2- Inspect par	ts off machine FAI/FAIB	0.00	e de la companya de l		_ (€O_			JFC 20)14-03
QC Quality Control	Men	10	0.00				,			`	., 00

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE					AEROSPACE
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					_	Rework		Skid-tube Crosstube				Water Jet			Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	٦	Quality
	•					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	۱o. ِ					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Actio	n		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification		QC Inspector
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	<u> </u>	Bending Centre No	nt Cancar	atric	-	BOM/Route	-	Grain	riogram		H	Over/Under	-	_	et-up
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		Marks/Ch				Drill Holes	H	Off-set							·
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	Turning Sequence Wave/Twist in Tube					Fit/Function		-{	Sequence						

Work Orde February-24-14				•	*11	37	<u>'98</u> *						Page	2
tem ID: Revision ID: Item Name:	D3404-1 GHW/ Lug				Accept	4	⁴ N900	040	100)* s	etup Star Stop	171	S1* S2*	·
Start Date: Required Date: Reference:	2/24/14 : 2/24/14	Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*	l e		Cust Item II Customer:	D:						
Approvals:	Process Pla	n:	Date:		Tooling: SPC (Y/N):			nte:		R	dun Star Stop	"IVI	R1* R2*	
Sequence ID/ Work Center II 130 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo	and check		Set Up/ Run Hours 0.00 0.00	DAS 14 9-89	Tool ID On Living	Tool#	Plan Code	Accept Qty 니ሪ	Reject Qty	Reject Number	Insp. Stamp]4/03/2C
*140 *140* Packaging Packaging	·	Identify as per dwg & Sto	ock Location:	W/A @	0.00					40			14- (13-20 JBC
150 *150* QC Quality Control		QC21- Final Inspection -	Work Order R	elease	0.00						w_	<u>COY</u>)	-20)	-
											MC	14.03	re	

DQA:			Date:										
						WORK ORDER NON-	-CC	NFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	lo.					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			1	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	10.					Suspected Unapproved	Large Fab Composite Supplier			· · · -			
Root					Desci	ription of work order update	I	nitial	Ac	ction	Sign &	•	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng		cription	Date	 Verification 	QC Inspector
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	_	<u> </u>		<u> </u>	ł		FAI	ULT CA	TEGORY		 	•	
Landi	ng (Gear				General				•		-	
	Ť	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	:t	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Jnqualified	Part Lost/Mi	ssing	Weld_
				Contamination • .		Instruct	tions Incomplete,	/Unclear	Part Moved	<u>.</u>	Wrong Stock Pulled		
		Crushing				Countersink		Misalig	gned/off center	·	Positioned V		- 1
	L	Heat Trea	at			Cut Too Short		Mislab		<u> </u>	Power Loss/	Surge	Other
	L	Inspectio		Tube		Drawing		Misrea				4	
]		Marks/Ch			\vdash	Drill Holes	\vdash	Off-set					
		Turning S	-			Finish		4	Calibration				
1	Wave/Twist in Tube				Fit/Function		Out of	Sequence					

February-24-14 10:03:56 AM

Work Order ID: 113798

113798

Parent Item:

D3404-1

D3404-1

Parent Item Name: GHW/ Lug

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.09.01New issueKJ/JLM

IPP rev B 09.01.28 new geometry rev C

EC verified by:DD

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500 *M304B0 7 604 BAR .750 X 2.50	'50X2 5	Purchased 500*	No		128496	100 Y	9.65	0.7812	0.2291 ** DA 02	1	14	_03	-17
				<u>Locatio</u> MATO	_		<u>Oty</u> .7812	Loc Code	•	•			

DQA:			Date:											
						WORK ORDER NON-	-CC	NFO	-			-	AEROSPACE	
QA Closed:			Date:			·		***		Wo	ork Order up	odate only		
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Orac	•	·····				Rework			Skid-tube Crosstube			Water Jet	Engineering	
Part N	lo.					Scrap	ļ		Machining Small Fab		Pro	d. Eng. Coor.	Quality	
	•					Use-as-is			noforming Finishing		Rec/Stor	re/Packaging	Other	
NCR N	lo.					Suspected Unapproved			Large Fab Composite		·	Supplier		
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design						•								
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Landi	na (300F				General	FA	ULI CA	IEGONT					
Lanui	lig (Bending				Bend		l _{Eolio} /F	Program		Outside Dim	ensions [Pressure/Forced	
		Centre No	nt Concer	ntric	-	BOM/Route	-	Grain	10814111	\vdash	Over/Under	-	Set-up	
		Cracks	or concer	10.10		Broken/Damage/Defect	\vdash	Hardwa	are	H	Part Incorre	-	Temperature/Cure	
		1	nk/Ripple	/Wave		Burrs		₹	tion Incomplete/Unqualified		Part Lost/Mi	 -	Weld	
	\vdash	Crimp/Kink/Ripple/Wave Cuffs			Contamination		1	tions Incomplete/Unclear		Part Moved	_	Wrong Stock Pulled		
	\vdash	Crushing				Countersink		4	gned/off center		Positioned \			
		Heat Trea	it			Cut Too Short	-	Mislab		Г	Power Loss/	/Surge	Other	
	Г	Inspectio		Tube		Drawing		Misrea	d					
		Marks/Ch				Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	113798
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	0.512	V		Calipert Pin	JFC-01+Shop
R0.65	+/-0.030	RO.65	✓		Caliper Rul b	i il
0.125	+/-0.010	0.125	/		Caliner	JFC-01
0.500	+/-0.010	0.5006			il	•
2.14	+/-0.030	2.140			H6	31006
1.30	+/-0.030	1.300	✓		Caliper	Ifeoi
R2.30	+/-0.030	P2/30	V		Rad 5	Shop
1.14	+/-0.030	1.140	V		Caliper	JFC-01
2.58	+/-0.030	2-579	/		1.	C,

	DAS		
Measured by: JfC	Audited by:	Prototype Approval:	N/A
Date: 2014-03-18	Date: 14/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.04.12	New Issue	KJ/JLM ,	11
В	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD KJ	Coll

D D 113798MC5 1402-26 С **D3404-1 GHW LUG** DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20. 08.12.02 В UPDATE M-SPEC PH 05.06.14 Α NEW ISSUE РН 05.03.08 NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 REF. DART SPEC. M304B REV. DESCRIPTION DATE BY DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) MEIOTIFIC 0.34 IN: DRAWING NO. CHECKED REV. C D3404 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE GHW LUG DE APPR. NTS 7) WEIGHT: 0.34 lbs COPYRIGHT © 2005 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE OR COMPANION THE PROPERTY. DATE 08.12.02

